

Work Order ID 82760

April 9, 2012 8:33:18 AM

82760

Page 1

Item ID: D3394-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug Assembly

Start Date: 4/09/12 Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/30/12 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: *CL*

Date: *12/04/09* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3394 DEO

Rev B

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank to .850"

cut @ meter

120

0.00

120

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

MILL AS PER DWG AND FOLIO FA808

FOLIO REV: _____

DWG REV: _____

DEBURR

puerch issue PRO+ meter

PRO: 16655

*machine as per dwg D 3394
REV. B*

CL 12/04/09 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82760

82760

Page 2

April 9, 2012 8:33:18 AM

Item ID: D3394-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug Assembly

Start Date: 4/09/12 Start Qty: 20.00

20

Cust Item ID:

Required Date: 4/30/12 Req'd Qty: 20.00

20

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

130

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

rec'd + inspect for transit damage
attached cufc to wro

135

135

QC

Quality Control

QC2 Inspect parts - second check

0.00

Memo

0.00

8/2/12/18

cauler
720

140

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

20716 12-418 JDR

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82760

82760

Page 3

April 9, 2012 8:33:18 AM

Item ID: D3394-043 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lug Assembly
 Start Date: 4/09/12 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 4/30/12 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:10	OVEN TEMPERATURE:							
	FINISH TIME: 3200F	9:40							
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170		0.00							
170	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3394								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 82760

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Page 4

April 9, 2012 8:33:18 AM

Item ID: D3394-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lug Assembly
 Start Date: 4/09/12 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 4/30/12 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				cuts (420)			
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: 179 Memo	0.00 0.00				200			12/4/23
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/4/23

11204-23

Picklist Print

April 9, 2012 8:33:17 AM

Page 1

Work Order ID: 82760
Parent Item: D3394-043
Parent Item Name: Lug Assembly

Start Date: 4/09/12
Start Qty: 20.00

Required Date: 4/30/12
Required Qty: 20.00

Comments: IPP Rev: A New Issue 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS35489-93 GROMMET		Purchased	No			100	Each	206.0000	2	40		4/12/04/19	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST293		100							
				121255		100							
				ST295		78							
				120769		78				40			
				ST296		28							
				116235		28							
D2423 Lug Extrusion		Manufactured	No			110	f	288.5790	0.07	1.4736842		4/12/04/09	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT006		288.579							
				43722		161.5							
				45800		1							
				68331		126.079				1.4774			
D3394-3P Lug		Purchased	No			170	Each	0.0000	1	20		4/12/4/18 (20)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

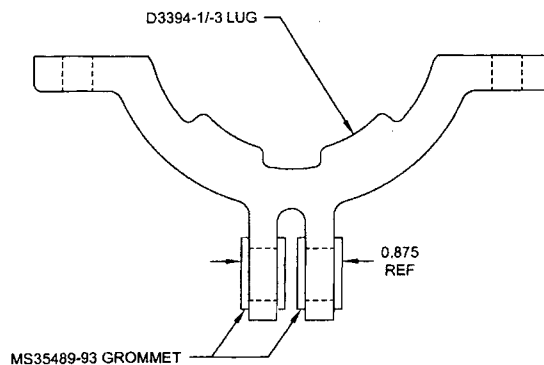
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

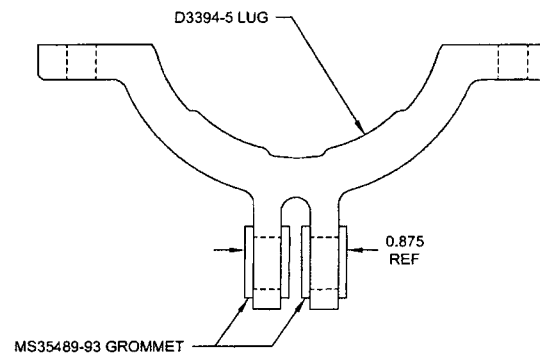
NOTE: Date & initial all entries

QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3394-041	LUG ASSEMBLY
	X		D3394-043	LUG ASSEMBLY
		X	D3394-045	LUG ASSEMBLY
1			D3394-1	LUG
	1		D3394-3	LUG
		1	D3394-5	LUG
2	2	2	MS35489-93	GROMMET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82760
1204-5



D3394-041/-043 LUG ASSEMBLY



D3394-045 LUG ASSEMBLY

DEO ATTACHED

RELEASED
09/04/02

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.20 lbs APPROX

B	ADDED -045, SHT 4 ADDED FILLETS IN SECTION A-A. SEE PAR 152	AJS	09.04.02
A	NEW ISSUE	PH	05.02.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
DATE	09.04.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

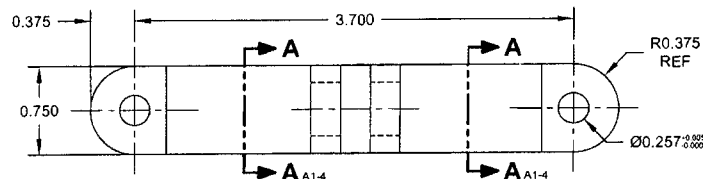
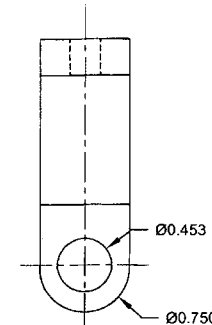
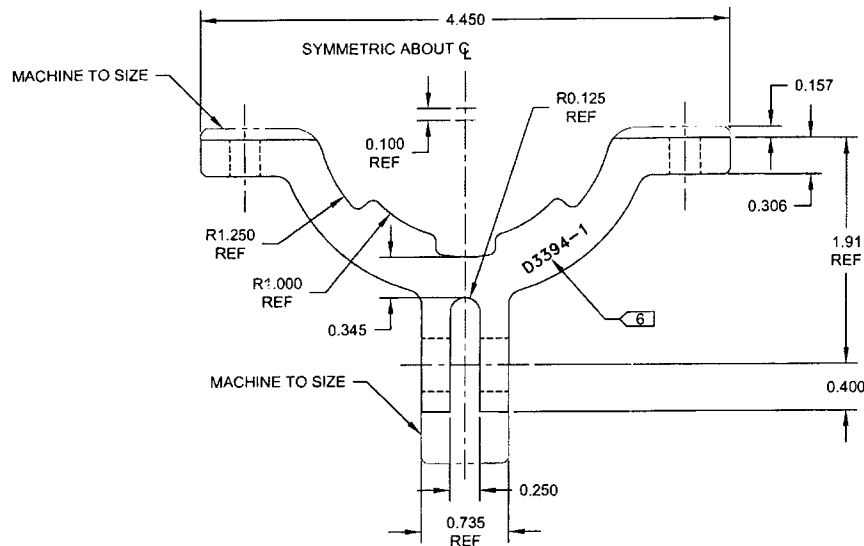
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3394-1 LUG

82760

DEO ATTACHED

RELEASED
09/26/23

NOTES:

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION.
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
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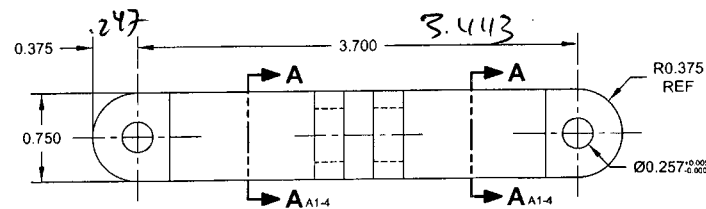
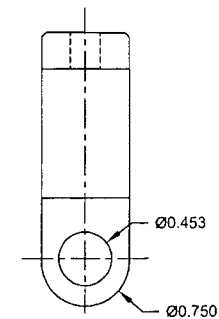
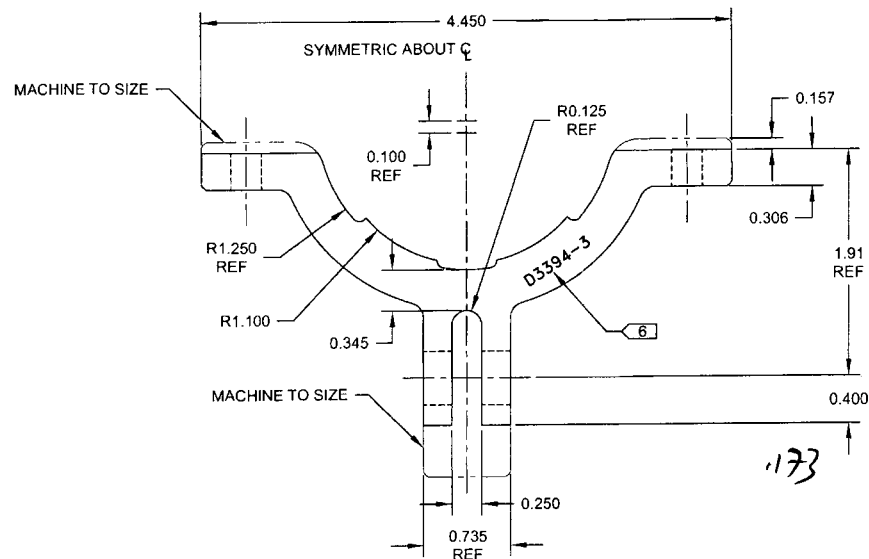
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3394-3 LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,
WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DEO ATTACHED

RELEASED
09/04/02

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3394	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LUG	NTS
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Dart Aerospace Ltd

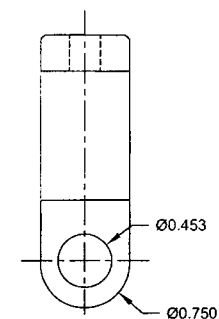
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

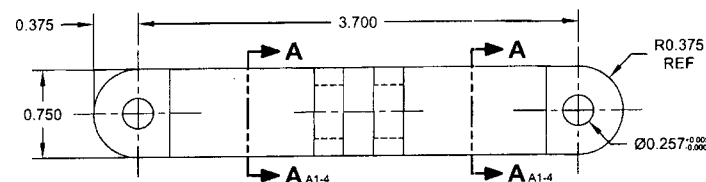
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



82780



R0.125
2 PL

DEO ATTACHED


RELEASED

01/06/25 MP

A B5-2
B4-2
B5-3
B4-3
B5-4
B4-4

NOTES:

- 1) MATERIAL: MAKE FROM D2423
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
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WITH TOOL A TIP RADIUS OF 0.015±0.005
- 7) WEIGHT: 0.18 lbs

DESIGN	PH		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		DRAWING NO.	REV. 1
CHECKED			D3394	SHEET 4 OF 4
MFG. APPR.			TITLE	SCALE
APPROVED			LUG	NT
DE APPR.				
DATE	09.04.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT PERMISSION FROM DART AEROSPACE LTD</small>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

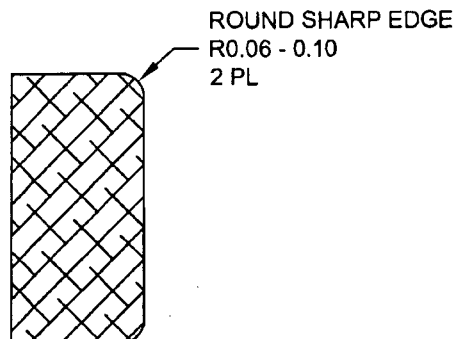
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3394-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 09.11.04	DATE 09.11.04	DATE 09.11.04	DATE 09.11.04		DATE 09.11.04		

SHEET 4 ZONE A,1 MODIFY SECTION A-A AS SHOWN:

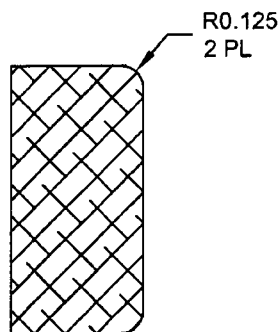
IS:



SECTION A-A

82760

WAS:



SECTION A-A

RELEASED
2009-11-25
[Signature]

REASON: DRAFTING ERROR

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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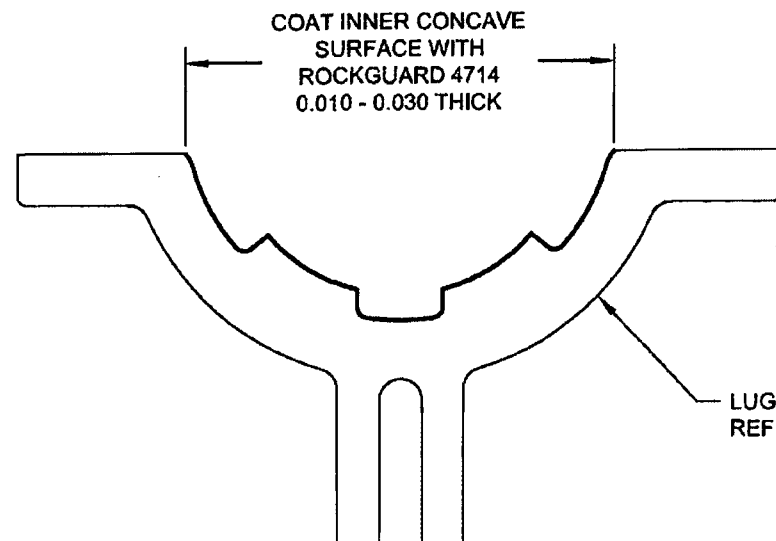
DRAWING NO. D3394	TITLE LUG	REV. B	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3394-B-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>GP</i>	CHECKED <i>Sc</i>	MFG. APPR. <i>M</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 11.05.02	DATE 11.05.09	DATE 11.05.09	DATE 11.05.09		DATE 11.05.09		

PURPOSE

ADD D3394-xRG OPTION

CHANGE

D3394-xRG MOUNTING LUGS ARE INDENTICAL TO D3394-x MOUNTING LUGS, HOWEVER AFTER FINISH, COAT INNER CONCAVE SURFACE WITH "PLUS ONE ROCKGUARD 4714" AS SHOWN BELOW.



82760

RELEASED
2011-05-26
WMB

D3394-1RG LUG (SHOWN)
D3394-3RG/-5RG LUGS (SIMILAR)
D3394-041RG/-043RG/-045RG LUG ASSEMBLIES (SIMILAR)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16655

Purchase Order Date 4/09/12

PO Print Date 4/09/12

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

10127-2607

Tax Resale Nbr

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FXED
C/L 12/04/09

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3394-3P	Lug	4/25/12 Yes	20.00 Each	Dart Truck	\$18.9500	\$379.00

Special Inst: AS PER DWG D3394 REV. B
B82760

PO Total:

\$379.00

Change Nbr: 1

Change Date: 4/09/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

→ Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
20	D3394-3P	Lug	16655

8/17/12

MATERIAL: supplied by DART B68331

→ We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, April 12, 2012